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(54) Title: NONWOVENS FROM POLYTRIMETHYLENE TEREPHTHALATE BASED STAPLE FIBRES

(57) Abstract: A method for making a nonwoven web from staple fibres of polytrimethylene terephthalate which comprises: (a) making polytrimethylene terephthalate fibres having a cut length of from 10 to 200 millimetres and a fibre weight of 0.1 to 20 deniers per filament; (b) carding the staple fibres at a belt speed of up to 1000 meters per minute, a cross lap of web of from 1 to 50 layers and a web weight of 5 to 500 g/m^2 in a carding machine selected from the group consisting of roller-top, flat-top and layering types, to produce a nonwoven web; and (c) mechanically bonding the web by hydroentanglement at a belt speed of up to 500 metres per minute with from 1 to 10 multiple passes and water jet hydraulic pressure of 100 to 50000 kPa (1 to 500 bar).

NONWOVENS FROM POLYTRIMETHYLENE TEREPHTHALATE BASED STAPLE FIBRES

Field of the Invention

The present invention relates to the manufacture of nonwoven fabrics from polytrimethylene terephthalate (PTT) based staple fibres. More specifically, the present invention relates to a process for producing such nonwovens which involves forming the web by carding the PTT fibres and then mechanically binding them by hydroentanglement.

Background of the Invention

As described in the 1987 Encyclopedia of Polymer Science and Engineering, Volume 10, page 204+, nonwoven fabrics are porous, textile-like materials, usually in flat sheet form, which are composed primarily or entirely of fibres assembled in webs. Nonwoven fabrics are manufactured by processes other than spinning, weaving, or knitting. The ASTM definition of nonwoven fabrics is "a structure produced by bonding or the interlocking of fibres, or both, accomplished by mechanical, chemical, thermal, or solvent means and the combination thereof." The biggest advantage of nonwoven fabrics is their cost to manufacture and that they are usually made directly from raw materials in a continuous production line which allows the manufacturer to eliminate a number of conventional textile operations.

Thin woven webs can be formed of most natural fibres, including wood pulp, cotton, and manila hemp. Rayon and cellulose acetate are also used. Presently, synthetic fibres including polyethylene terephthalate,

nylon-6, nylon-6,6, polypropylene, and polyvinyl alcohol fibres are used in commercial nonwoven fabric manufacture.

Staple fibres are used as the raw material for the manufacture of nonwoven fabric webs. Staple fibres are fibres which are long enough to be used in conventional spinning equipment. Generally, the fibres are between 1.2 and 20 centimetres long, but some fibres may be longer than that. Dry processing methods, such as carding and air-laying, are used in the formation of the nonwoven web.

In carding, the webs are produced using conventional textile carding machines. Bales of staple fibre are opened by machines equipped with sharp teeth or needles to tear the fibres. This process is called picking. Clumps of staple fibres from the picking process are first separated mechanically into individual fibres and then formed into a coherent web in the carding machine which utilizes opposed moving beds of closely spaced needles to pull and tease the clumps apart. There is a large rotating metal cylinder covered with card clothing (comprised of needles, wires, or fine metallic teeth embedded in a heavy cloth or a metal foundation) at the centre of the machine. The moving beds of needles are wrapped on or around the cylinder and narrow metallic flaps which are held on an endless belt moving over the top of the cylinder. The cylinder moves faster than the flats and the clumps between the two beds of needles are separated into individual fibres which are then aligned in the machine direction as each fibre is held at each end by individual needles from the two beds. The fibres engage each other randomly and form a coherent web.

After the web is formed, the fibres must be bonded in order to form a web with sufficient strength. Bonding can be carried out by both adhesive and mechanical means. Types of adhesive bonding include latex bonding, print bonding, spray bonding, foam bonding, and thermal bonding. Mechanical bonding utilizes frictional forces between the fibres and methods include hydroentanglement (spun lace, water punch), needle punching, and stitch bonding.

In the hydroentanglement process, high pressure water jets entangle the fibres. Usually, a staple fibre web is made on a perforated belt and is passed under high pressure water jets. The high pressure jets of water cause the fibres to migrate and entangle including to the perforation in the belt. The belt is then impregnated with binder in order to seal segments of the structure. US-A-3485706 describes a hydroentanglement process for making nonwoven webs.

JP-A-11089869 describes a composite structure having air permeability which is formed by laminating a thermoplastic synthetic resin film on to a nonwoven fabric consisting of PTT fibre. PTT was used because the final product was softer and better in elasticity than polypropylene, polyethylene terephthalate (PET), or polyamides (PA or nylon). The recommended method for making the nonwoven fabric is spun bonding, in which fibres and web are made simultaneously directly from the bulk polymer. The bulk polymer is melted, extruded, and drawn to filaments that are randomized and deposited on to belts as a continuous virtually endless web. The melted polymer is forced through very fine holes in a special die into a high velocity air stream wherein the polymer is formed to very fine, although irregular,

filaments of indeterminate lengths. The reference generally states that other methods, such as carding, can be used to make the web and that the web can be further treated by other methods, including hydroentanglement, although no details are provided.

Summary of the Invention

In accordance with the present invention there is provided a method for making a nonwoven web from staple fibres of polytrimethylene terephthalate which comprises:

(a) making polytrimethylene terephthalate fibres having a cut length of from 10 to 200 millimetres and a fibre weight of 0.1 to 20 deniers per filament;

(b) carding the staple fibres at a belt speed of up to 1000 meters per minute, a cross lap of web of from 1 to 50 layers and a web weight of 5 to 500 g/m^2 in a carding machine selected from the group consisting of roller-top, flat-top and layering types, to produce a nonwoven web; and

(c) mechanically bonding the web by hydroentanglement at a belt speed of up to 500 metres per minute with from 1 to 10 multiple passes and water jet hydraulic pressure of 100 to 50000 kPa (1 to 500 bar).

The present invention relates to making high quality, soft and relatively elastic nonwoven fibre webs from polytrimethylene terephthalate (PTT). Staple PTT fibres are first manufactured. Usually, this involves spinning the polymer into fibres and then cutting them to a length of from 10 to 200 millimetres, preferably 25 to 80mm, and a fibre weight of 0.1 to 20, preferably 0.5 to 10, deniers per filament. Thereafter, the fibres are carded and hydroentangled. This combination of steps produces high quality PTT nonwoven fabrics, i.e. which are softer than fabrics from other materials, require

less energy to hydroentangle, can be manufactured at higher carding rates, and have a higher dye yield.

The PTT staple fibres are first carded. This can be carried out in conventional carding machines wherein the web is crosslapped at a belt speed of up to 1000, preferably 10 to 1000, most preferably 100 to 300, metres per minute, a cross lap of web of 1 to 50 layers, preferably 3 to 10, and a web weight of 5 to 500 g/m^2, preferably 10 to 100, in a carding machine selected from the group consisting of roller-top, flat-top, and layering types. The web is mechanically bonded by hydroentanglement at a belt speed of up to 500 metres per minute, preferably 5 to 500, most preferably 50 to 200, with from 1 to 10 multiple passes and a water jet hydraulic pressure of 100 to 50000 kPa (1 to 500 bar), preferably 500 to 25000 kPa (5 to 250 bar). The process requirements for the carding are preferably: Carding at 3 metres/minute to give a target web weight of 50 g/m^2 with 8 layers of crosslapping. Hydroentanglement can be carried out in conventional textile hydroentanglement apparatus including water jet injection, dewatering or vacuum boxes, a filtration, a water removing system, a perforating unit, drying, and winding. Special apparatus and process conditions for the hydroentanglement of PTT include lower water jet pressure needed than that normally used for PET and nylons.

Brief Description of the Drawings

The present invention will now be described by way of example with reference to the accompanying drawings in which:

Figure 1 shows the stress strain curves for the three test fibres used in the examples;

Figure 2 shows the effect of specific energy on fabric break strength for a 100 mesh screen for five of the polymers tested;

Figure 3 shows the effect of specific energy on fabric break strength for the same fibres for a 12 by 14 mesh screen;

Figure 4 shows the effect of specific energy on flexile rigidity for a 100 mesh forming screen;

Figure 5 shows the effect of specific energy on flexile rigidity for a 12 by 14 mesh screen;

Figure 6 shows the effect of specific energy on tear strength for a 100 mesh screen;

Figure 7 shows the effect of specific energy on tear strength for a 12 by 14 mesh screen;

Figure 8 shows the break strength - flexile rigidity tradeoff for a 100 mesh screen;

Figure 9 shows the break strength - flexile rigidity tradeoff for a 12 by 14 mesh screen;

Figure 10 shows the tear strength - bending rigidity tradeoff for a 100 mesh screen;

Figure 11 shows the tear strength - bending rigidity tradeoff for a 12 by 14 mesh screen;

Figure 12 shows the strength versus flexibility of hydroentangled nonwovens for PTT, PET, and nylon-6 (50 g/m^2, 100 mesh support); and

Figure 13 shows the recovery of hydroentangled nonwovens from 10 percent strain as a function of forming energy.

Detailed Description of the Invention

There are a number of different types of mechanical carding machines that are used in the textile industry.

Roller-top, flat-top, and layer carding machines can be used in the present invention for PTT and blends of PTT and PET

The general processing conditions and steps under which the carding machines can be used are as described above.

For hydroentanglement, the general processing conditions and steps under which the hydroentanglement according to the present invention may be carried out are as described above. The water pressure used to achieve the entanglement may vary from 100 to 50000 kPa (1 to 500 bar), preferably 500 to 25000 kPa (5 to 250 bar). The formed entangling web are dewatered by suction boxes located immediately under the conveying element and corresponding to the jet manifolds. The web is dried by passing through a set of heated calendar rolls

Following hydroentanglement, the web is finished in order to provide a commercially saleable product. The following treatment steps may include spraying of adhesives and fabric softener. These webs can be used for wiping, wall paper and draperies, interlining fabrics, cotton bale bags, and many others as developed.

Key properties of PTT polymer are compared with other thermoplastics used in nonwoven fibre production in Table I.

Table I. Thermoplastics Used in Fibre Production

	PTT	PET	Nylon 6	Nylon 6,6	PP
Melting Point °C	228	265	220	265	168
Glass Transition, °C	45-65	80	40-87	50-90	-17 to -4
Density (g/cm³) % Water	1.33	1.40	1.13	1.14	0.91
Absorption (24 hours)	0.03	0.09	1.9	2.8	
% Water Absorption (14 days)	0.15	0.49	9.5	8.9	<0.03

PTT Properties Impacting Nonwovens

The stress strain curve for the PTT staple used in this work is compared to that of the Fortrel® T-472 PET fibre which was used and a typical nylon 6,6 staple fibre in Figure 1. PTT has several unusual features which it was initially felt could be important to nonwoven technology:

- Its elongation to break is significantly larger than either PET or nylon, promising improved tear strength
- Its initial modulus is lower than either control fibre, which results in reduced bending rigidity and hence a softer, more easily hydroentangled fibre.

In the nonwoven context, it was expected that PTT would provide a softer fabric and require less energy to hydroentangle. It was felt there would be other advantages including potential for higher carding rates and higher dye yield. PTT has also been shown to have very high recovery after compression in part because it has high fibre crimp retention. For example, if the bulk of slivers, which have been carded and drawn three times, are compared at a constant pressure of 5 cN/cm^2, it is found that PTT has a considerably higher specific volume than PET. This bulk advantage for PTT persists in spite

of its lower bending rigidity. It was felt that this would lead to a soft feeling, high bulk nonwoven.

The examples show the effects of these fibre properties on hydroentanglement efficiency and tensile, tear, and flexile rigidities of hydroentangled fabrics. The fibres used in this study are summarized in Table II.

Table II

Fibre	Dtex*	Length, mm	Source
PTT	1.7	38	CdP Type 725 Semi Dull Unwhitened
PET	1.7	38	Wellman T-472 Semi Dull Optically Brightened
Nylon	1.7	40	Rhodia, Type R174 Matt Dull

* A unit for expressing linear density

<u>Examples</u>

All experiments were performed in the Nonwoven Cooperative Research Center's laboratory/pilot plant at the North Carolina State University, Raleigh, North Carolina which has carding, hydroentangling, needle punch, and thermal bonding equipment. The first set of experiments used a 10% PET, 90% PTT blend web prepared on a roller top card which was cross lapped to a 60 g/m^2 basis weight web. All other fibre blends were carded on a flat top card and cross lapped to 50 g/m^2 web weight. Webs were tacked for integrity and wound on spindles for further processing. A 50 cm web width was used for all experiments.

A roller top carding machine was used on the staple blend of 90% PTT and 10% PET (1.7 dtex and 38 mm cut length) supplied by Wellman. Eight carded webs were successfully produced at 60 g/m^2. The 90% PTT/10% PET carded webs were hydroentangled with two different sizes of supporting meshes (1. 100 and 2. 12 x10) successfully.

Three hydro heads were applied. Pressures were varied 1379 to 7240 kPa (200 to 1050 psi). A total of 6 samples were produced for each mesh size. The carded webs were thermal pointed bonded at temperatures starting at 130°C and up to 192°C at three different pressures (8.9, 26.6, and 44.3 N/linear cm (100, 300, and 500 pli [pounds per linear inch])). It appears bonding was not significant until 180°C.

A flat top carding machine by Signa Corp. was used to card the 100% PET staples successfully at 50 g/sq. m. web weight (Sample S2). Next a 50% PET + 50% Nylon (1.2 dtex, 38 mm) blend was carded also successfully at 50 g/sq. m (Sample S3). Next, a 50% PET + 50% PTT (1.2 dtex, 38 mm) blend was carded and successfully at 50 g/sq. m (Sample S4). A 100% Nylon (1.2 dtex, 38 mm) blend was carded and successfully at 50 g/sq. m (Sample S5). Last, carding of the staple of 100% PTT (Sample S6) was carried out. After going through the calendars, webs are laid 8 layers required to achieve the target 50 g/sq. m web weight at 3.66 m/min (12 ft/min) at the transfer station. Carded samples are summarized as in Table III.

Table III

Samples ID	Material Composition	Carding method
S2	100% PET	Flat Top
S3	50% PET + 50% Nylon	Flat Top
S4	50% PET + 50% PTT	Flat Top
S5	100% Nylon	Flat Top
S6	100% PTT	Flat Top

Hydroentanglement was carried out on a custom made apparatus/equipment in the NCRC's lab. The hydroentanglement conditions are summarized in Table IV.

Table IV
Hydroentanglement Variables

Variable	Range Investigated
Jet Density	15.8 jets/cm
Jet Diameter	0.127 mm
Discharge Coefficient	0.7
Number of Manifolds/Pass	3
Number of Passes/Trial	2 with sides reversed
Speed	1.13 m/min
Pressure Range	690-72400 kPa (6.9-72.4 bar)
Low Aperture Forming Screen	100 mesh
High Aperture Forming Screen	12x14 mesh

All of the fabrics were characterized in a similar manner. Tensile testing used ASTM 5035-90 and tested a 25.4mm wide strip with a 76.2mm gauge. Flexile rigidity was determined using IST 90.1. Tear strength used the trapezoid tear method ASTM D5733-95. All strength data was normalized to the average basis weight for the set under consideration. To simplify the analysis MD and CD results were averaged.

Hydroentanglement Results

In the first experiment, the 90% PTT / 10% PET fabric achieved significant tear strength at 40 kJ/kg specific energy and there is little consistent effect of forming screen type on tear strength (Figure 2).

The initial experiment was extended to the five additional blends of the fibre types summarized in Table II.

- 100 % PET
- 50/50 % PET / Nylon
- 50/50 % PET / PTT
- Nylon
- PTT

Break Strength

All fibres tested, except nylon, exhibited the same response to increasing specific energy. An initial rapid increase in break strength was followed by a plateau where increasing energy did little to increase break strength. The nylon sample was the exception with strength increasing nearly linearly with specific energy. Results are illustrated on Figures 2 and 3.

The threshold energy required to reach the break strength plateau is less for PTT containing blends. Table V lists the lowest energy required to reach the plateau for both meshes and the blends tested. Table VI lists the break strength the lowest energy required to reach the strength plateau. PTT is competitive in strength with the other blends, and requires significantly lower energy.

Table V
Specific Energy Required to Reach
Break Strength Plateau

Fibre Blend	100 Mesh Screen, kJ/kg	12x14 Mesh Screen, kJ/kg
PET	120	320+
50/50% PET/Nylon	200	270+
50/50% PET/PTT	90	320+
Nylon	320+	270+
PTT	75	120

Table VI
Break Strength at Plateau Specific Energy

Fibre Blend	100 Mesh Screen, N	12x14 Mesh Screen, N
PET	58	51
50/50% PET/Nylon	48	42
50/50% PET/PTT	47	40
Nylon	26	38
PTT	49	42

Flexile Rigidity

Flexile rigidity results for both low and high aperture forming screens presented in Figure 4 and 5 indicate that flexile rigidity is relatively independent of specific energy for all fibres tested. Flexile rigidity for PTT was somewhat higher than expected given the fibre's low bending rigidity, but the PTT fabrics tended to be higher weight because they are more easily consolidated by the jets.

Overall the flexile rigidity ranking for the 100 mesh screens in order of decreasing rigidity are:

- PET
- PTT
- PET/Nylon
- PET/PTT
- Nylon

Overall the flexile rigidity ranking for the high aperture 12x14 mesh screens is:

- PET and PTT (Tie)
- PET/Nylon
- PTT/PET and Nylon (Tie)

Tear Strength

As specific energy increases, tear strength increases rapidly until a plateau value is reached where further energy increases provide no significant additional strength benefit. This behaviour (Figures 6, 7) is completely analogous to the effect observed for tensile strength. Table VII presents the plateau energy for each fibre tested. Table VIII presents the tear strength at the plateau energy. PTT containing blends provide competitive tear strength at significantly lower energy levels.

Table VII
Specific Energy Required to Reach
Tear Strength Plateau

Fibre Blend	100 Mesh Screen, kJ/kg	12x14 Mesh Screen, kJ/kg
PET	250+	170
50/50% PET/Nylon	250+	280+
50/50% PET/PTT	100	190
Nylon	300+	260+
PTT	130	50

Table VIII
Tear Strength at Plateau Specific Energy

Fibre Blend	100 Mesh Screen, N	12x14 Mesh Screen, N
PET	50	52
50/50% PET/Nylon	58	48
50/50% PET/PTT	46	41
Nylon	39	48
PTT	45	40

<u>Break Strength - Flexile Rigidity Tradeoff</u>

The ideal fabric would have high tensile and tear strength and low flexile rigidity. In practice this often involves a balance between high strength and increased flexile rigidity, and lack of drape. Figures 8 and 9 are cross plots of break strength and bending rigidity. The desired fabric is located in the lower right hand corner of this plot. When the preferred region is defined as flexile rigidity < 20 mg*cm and break strength >40N, 5 of the 7 low aperture (100 mesh) fabrics in this region contain PTT. For the coarse aperture (12x14) fabrics 1 of 3 goal fabrics contain PTT.

Figures 10 and 11 illustrate the tear strength, flexile rigidity balance for all fibre types tested. Again, arbitrarily defining the desired area as < 20 mg*cm rigidity and > 40 N tear strength, 5 of 7 fabrics

in the goal area for the 100 mesh screen contain PTT and 3 of 5 fabrics for the high aperture 12x14 mesh screen contain PTT.

It is concluded from the foregoing that PTT will provide a more drapeable fabric with good strength compared to the other fibres tested. Drape describes the way a fabric falls as it hangs and the suppleness and ability of a fabric to form graceful configurations.

Fabric Softness

When one touches and rubs the surface of a fabric, fibres that bend easily generally feel softer. For example, fabrics containing a microfibre generally feel much softer than the same polymer substrate at a higher dtex. Not surprisingly, hydroentangled fibres containing PTT are generally rated softer to the touch. Results of an informal tactile testing of fabrics from this set of experiments resulted in the following ranking, from high softness to low softness:

PTT > Nylon > 50/50% PET/PTT > 50/50% PET/Nylon > PET

It is concluded from the foregoing that PTT will provide a softer, more pleasing fabric aesthetic. Because of its inherent low fibre bending rigidity in hydroentangled fabrics PTT provides the following characteristics:

- Significant break strength develops at very low specific energy levels (80 kJ/kg).
- Significant break strength develops at < 50 kJ/kg.
- Flexile rigidity does not increase with specific energy.
- Significant tear strength develops at 40 kJ/kg

When compared to PET, Nylon, and PET/Nylon blends, PTT containing fibres have comparable tensile strength, tensile elongation, and tear strength at significantly lower input energy levels. In addition PTT provides a favorable strength/flexile rigidity balance which should yield a more drapeable fabric. PTT fabrics are rated softer than the other blends in subjective aesthetic testing.

Recovery and Strength vs. Flexibility of Hydrolace Nonwovens

Figure 12 gives a comparison of similar hydroentangled fabrics made from nylon 6 and PET staple fibres, as well as PTT in terms of strength, elongation, and flexural rigidity. PTT has a good balance of strength achievable (above the threshold level) and rigidity as shown in Figure 12.

It can be seen that PTT offers a balance of low stiffness (approaching nylon) and high strength (approaching PET) otherwise achievable only with fibre blends. The strength of the fabrics reflects the ability of the PTT fibres to interlace easily, rather than their inherent fibre strength. As a measure of their elasticity, these webs were examined for recovery from 10% strain, showing the PTT webs to have recovery beyond that of the other webs examined, as shown in Figure 13.

COMPARATIVE EXPERIMENTS

During the course of these experiments, a roller top carding machine was used to card 100 percent PTT staples. This carding machine is commonly used for nonwovens. During this process, part of the web was carried by the roll and wrapped around them so the carding was unsuccessful. However, successful carding was achieved on the same machine using a staple blend of 90 percent PTT and 10 percent PET. Eight carded webs at 60 g/m^2

were successfully produced. An attempt was made to card the PTT stable on a Rando carding machine via the air laid method of carding. This was unsuccessful because the webs kept breaking and wrapping around the rolls.

The needle punch method of bonding the nonwovens was also tried. A Dilo machine with 228.6 punches per cm (90 punches per inch) was used and the experiments were carried out at 50, 100 (2 overlays), 150 (3 overlays) web weights and 7 millimetres in punch depth. The needle used was 15 (gauge) by 18 (taper related) by 32 (diameter related) by 7.62 cm (3 inch) (length). Based on tests by hand touch, the rank of softness is as follows and is similar to the rank for the hydroentangled webs listed above: PTT > nylon > PTT + 50% PET > nylon + 50% PET > PET. This test was not favourable because bonding strength was rather weak presumably due to the short staple used.

Five blends were investigated using the thermal bonding conditions shown in Table IX, 100 percent PET, 50/50 percent PET/nylon, 50/50 percent PET/PTT, nylon, and PTT. All experiments were run at 26.6 N/linear cm (300 pli) calendar row pressure, using a nominal 50 g/m^2 feed web. The PTT had a significantly greater shrinkage (basis weight gain) than the other blends.

The carded webs were thermal point bonded at temperatures per the following scheme (Table IX) all at 26.6 N/linear cm (300 pli) of pressure and line speed at 1.13 m/min.

Table IX

Calendar Bonding Conditions

Variable	Range Investigated
Roll Pattern	Diamond
Bond Area	25%
Speed	1.13 m/min
Temperature	100 to 225 °C
Pressure	8.8 to 44.2 N/linear cm

Table X is an overall comparison of the properties of these thermal bonded blends. In thermal bonding, PTT produced, in general, fabrics which were significantly weaker in both tensile and tear than PET, nylon and PET/nylon blends.

Table X
Property Comparison of
Thermal Point Bonded Fabrics

Fibre	Lowest Temperature with BS>30N or Highest Tested	Break Strength, N	Break Elongation, %	Flexile Rigidity, mg*cm	Tear Strength, N
PET	225	48	35	750	26
50/50 PET/Nylon	200	33	58	60	27
50/50 PET/PTT	210	22	43	100	17
Nylon	190	41	38	5	25
PTT	195	5	36	110	3

C L A I M S

1. A method for making a nonwoven web from staple fibres of polytrimethylene terephthalate which comprises:

(a) making polytrimethylene terephthalate fibres having a cut length of from 10 to 200 millimetres and a fibre weight of 0.1 to 20 deniers per filament;

(b) carding the staple fibres at a belt speed of up to 1000 meters per minute, a cross lap of web of from 1 to 50 layers and a web weight of 5 to 500 g/m^2 in a carding machine selected from the group consisting of roller-top, flat-top and layering types, to produce a nonwoven web; and

(c) mechanically bonding the web by hydroentanglement at a belt speed of up to 500 metres per minute with from 1 to 10 multiple passes and water jet hydraulic pressure of 100 to 50000 kPa (1 to 500 bar).

2. The method of claim 1 wherein the cut length in (a) is 25 to 80 mm and the fibre weight is 0.5 to 10 deniers per filament.

3. The method of claim 1 or 2 wherein the belt speed in (b) is from 10 to 1000 metres per minute.

4. The method of claim 2 or 3 wherein the belt speed in (b) is from 100 to 300 metres per minute, the cross lap is 3 to 10 layers, and the web weight is from 10 to 100 g/m^2.

5. The method of claim 1 or 2 wherein the belt speed is from 5 to 500 metres per minute.

6. The method of claim 1, 2, 3 or 5 wherein the belt speed is from 50 to 200 metres per minute with from 1 to 10 multiple passes and a water jet hydraulic pressure of 500 to 25000 kPa (5 to 250 bar).

Fig.1.

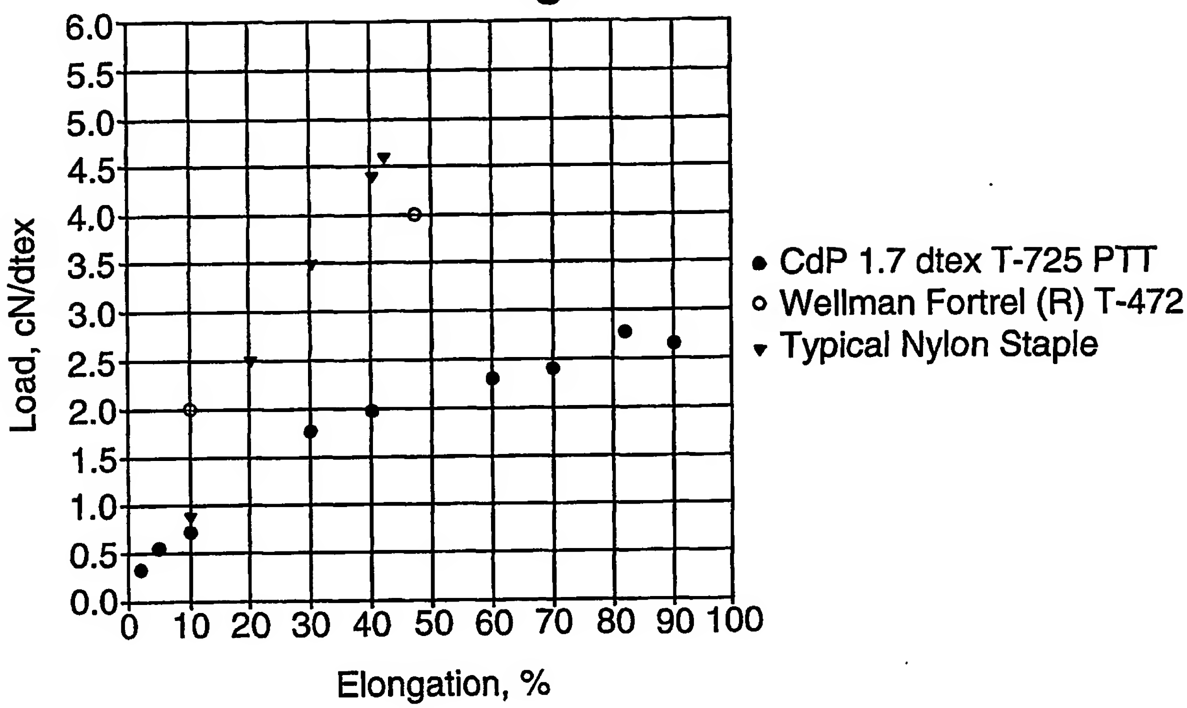
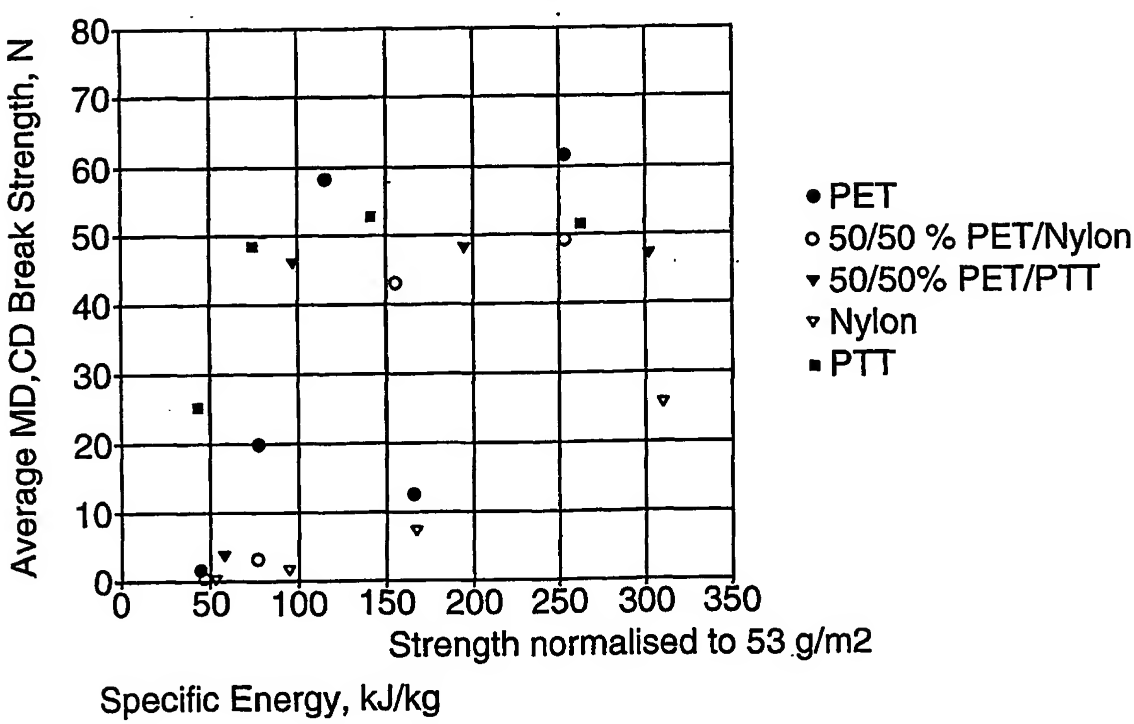

6.0
5.5
5.0
4.5
4.0
3.5
3.0
2.5
2.0
1.5
1.0
0.5
0.0
Load, cN/dtex
0 10 20 30 40 50 60 70 80 90 100
Elongation, %
CdP 1.7 dtex T-725 PTT
Wellman Fortrel (R) T-472
Typical Nylon Staple

Fig.2.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70
60
50
40
30
20
10
0
Average MD,CD Break Strength, N
0 50 100 150 200 250 300 350
Strength normalised to 53 g/m2
Specific Energy, kJ/kg
PET
50/50 % PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.3.

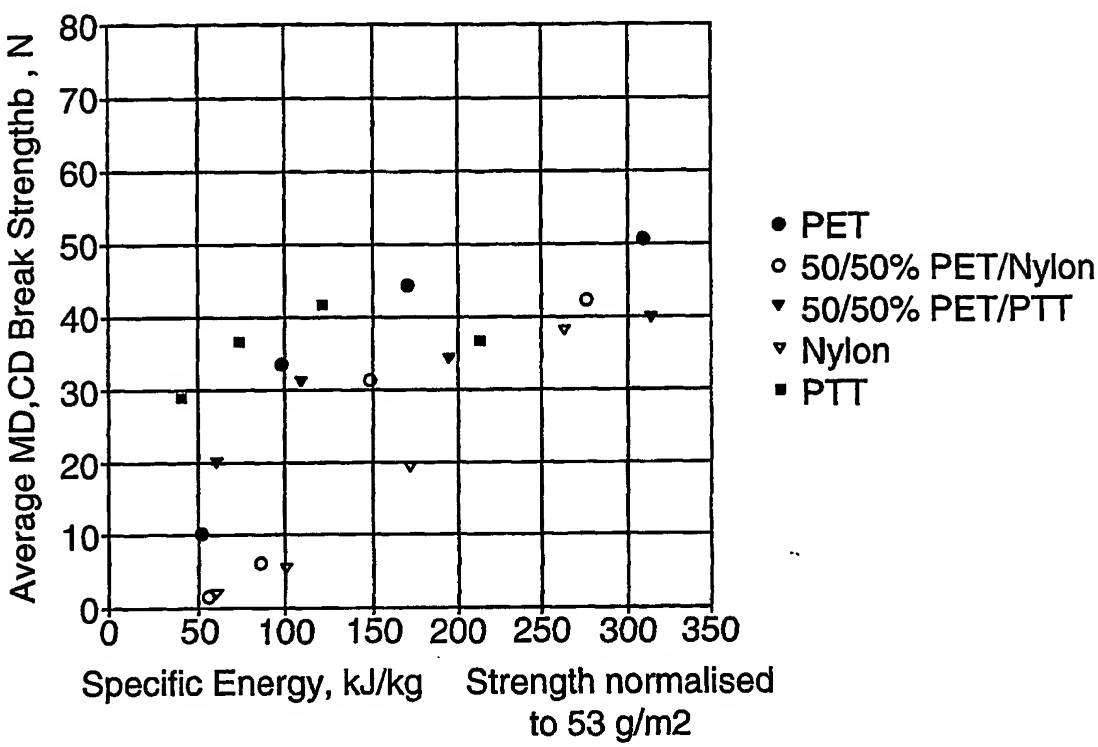

Average MD,CD Break Strengthb , N
80
70
60
50
40
30
20
10
0
0
50
100
150
200
250
300
350
Specific Energy, kJ/kg
Strength normalised to 53 g/m2
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.4.

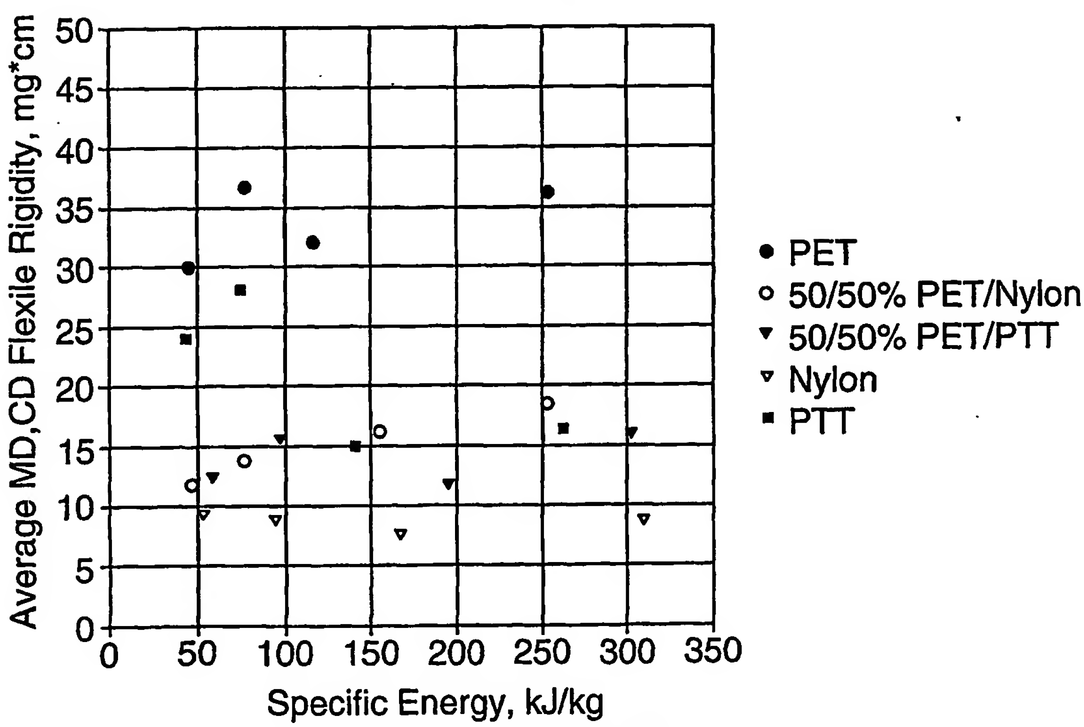

Average MD,CD Flexile Rigidity, mg*cm
50
45
40
35
30
25
20
15
10
5
0
0
50
100
150
200
250
300
350
Specific Energy, kJ/kg
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.5.

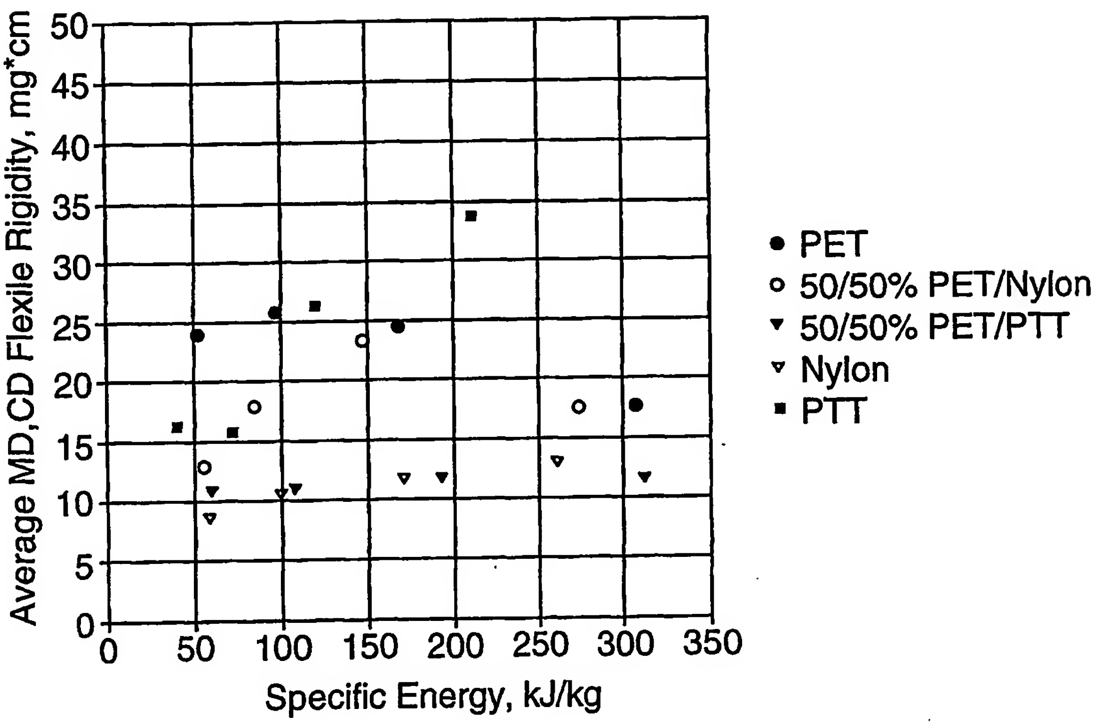

Average MD,CD Flexile Rigidity, mg*cm
0
5
10
15
20
25
30
35
40
45
50
0 50 100 150 200 250 300 350
Specific Energy, kJ/kg
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.6.

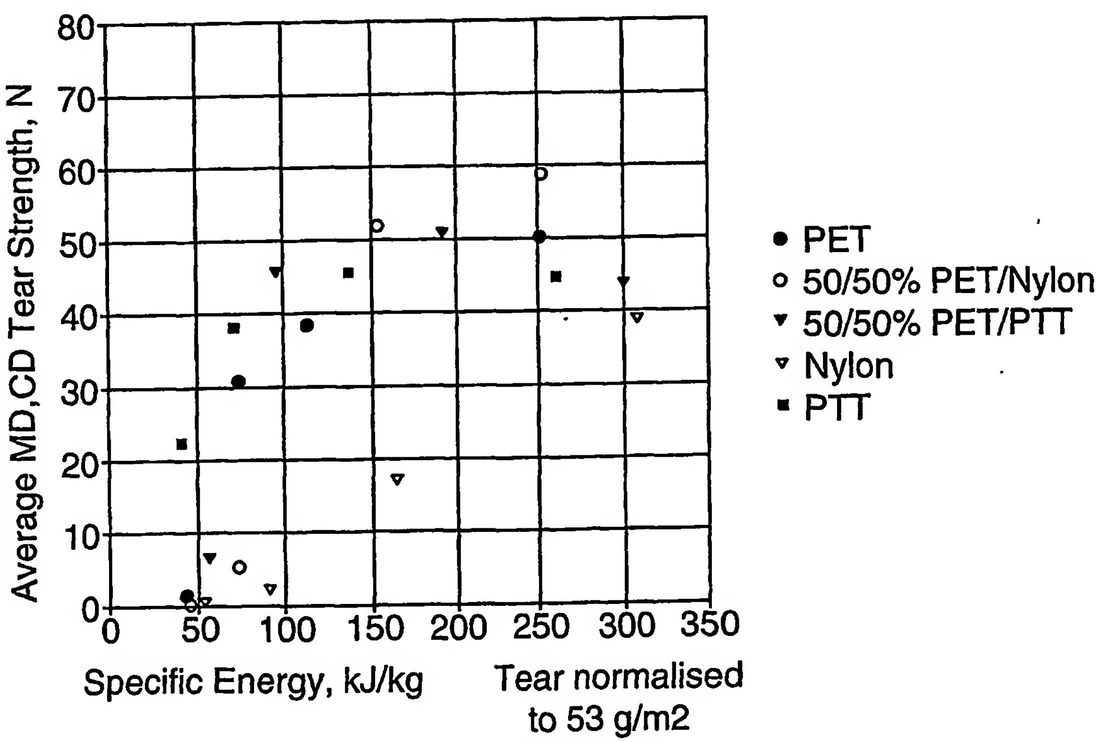

Average MD,CD Tear Strength, N
0
10
20
30
40
50
60
70
80
0 50 100 150 200 250 300 350
Specific Energy, kJ/kg
Tear normalised to 53 g/m2
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.7.

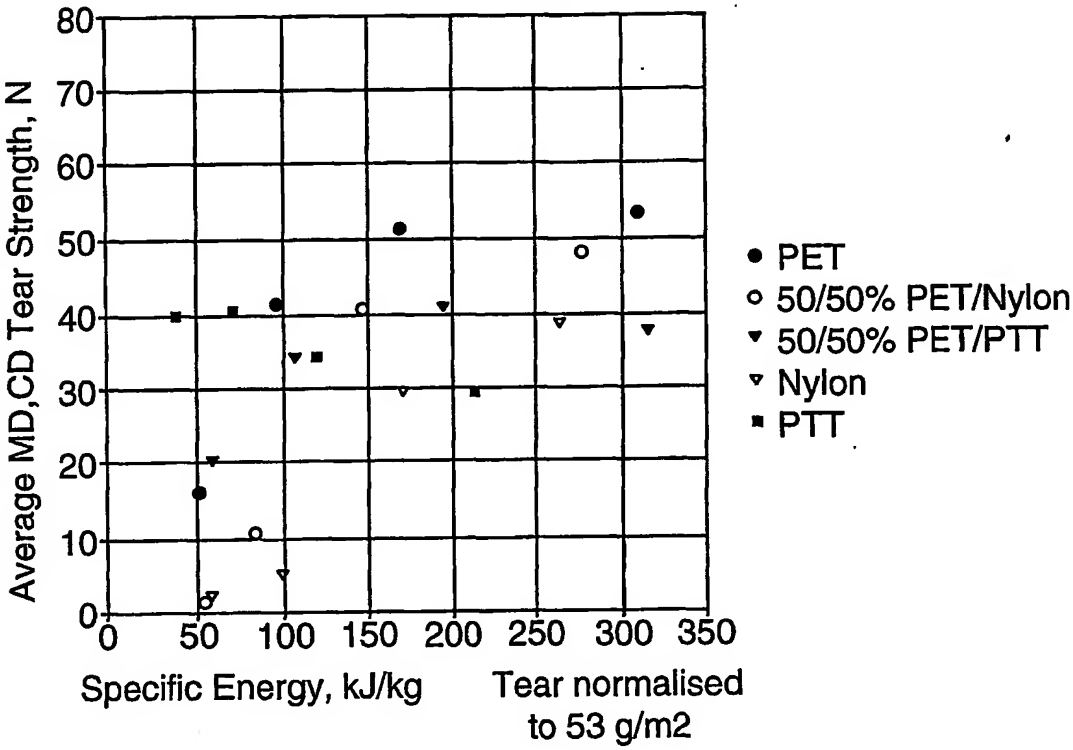

Average MD,CD Tear Strength, N
0
10
20
30
40
50
60
70
80
0
50
100
150
200
250
300
350
Specific Energy, kJ/kg
Tear normalised to 53 g/m2
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.8.

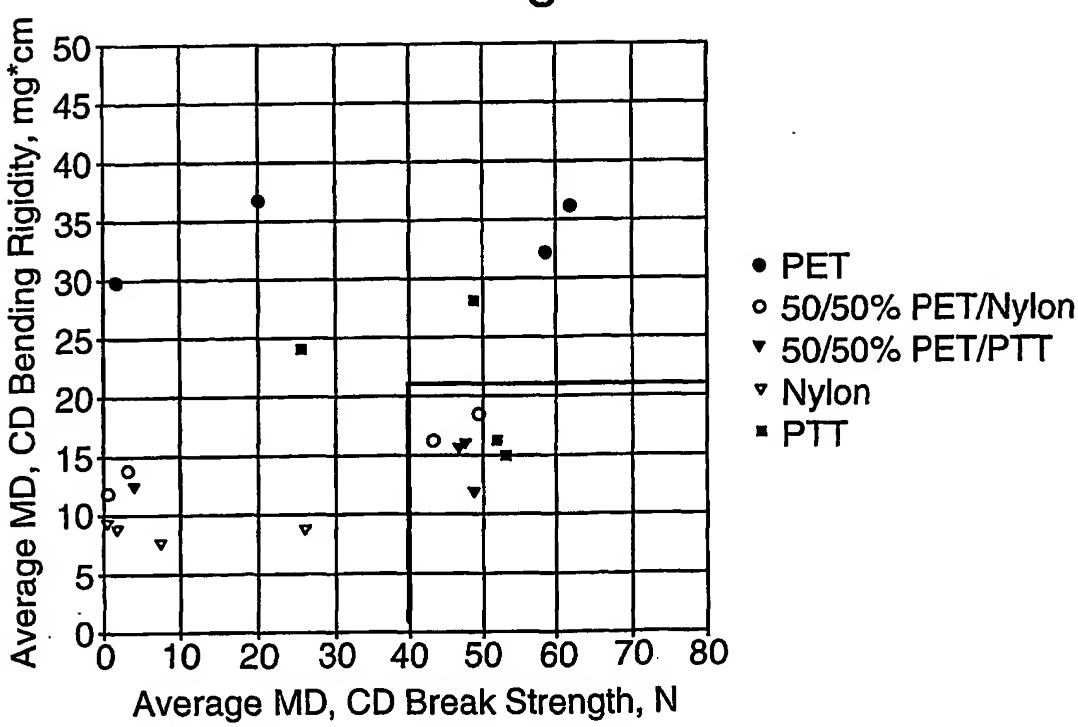

Average MD, CD Bending Rigidity, mg*cm
0
5
10
15
20
25
30
35
40
45
50
0
10
20
30
40
50
60
70
80
Average MD, CD Break Strength, N
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.9.

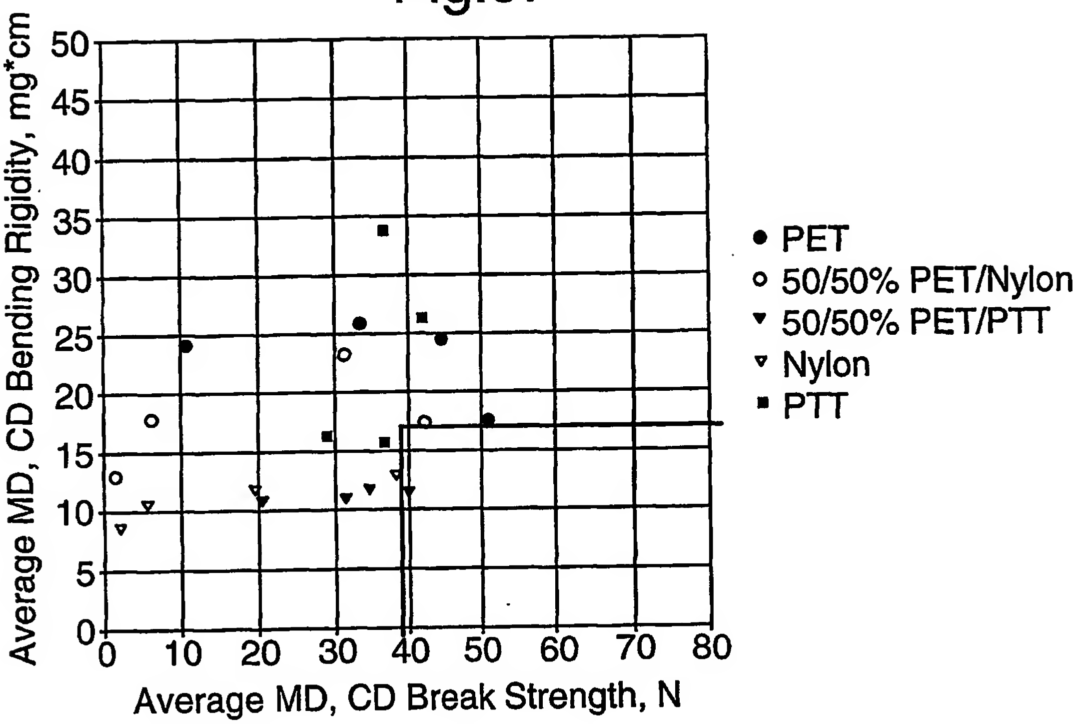

Average MD, CD Bending Rigidity, mg*cm
50
45
40
35
30
25
20
15
10
5
0
0
10
20
30
40
50
60
70
80
Average MD, CD Break Strength, N
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.10.

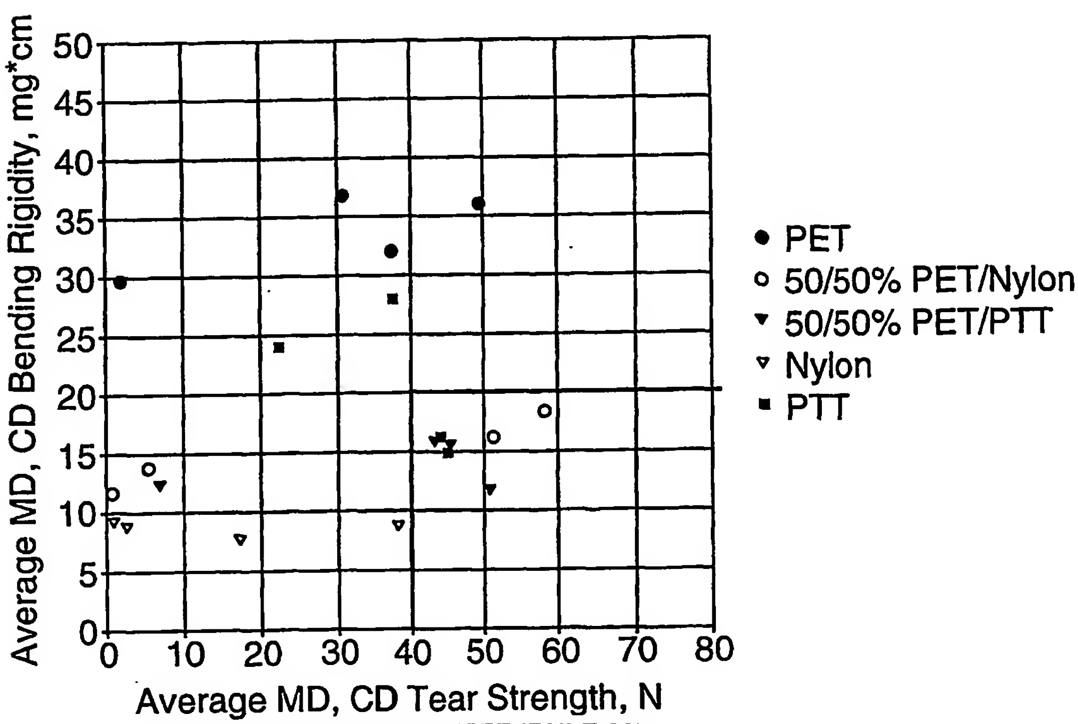

Average MD, CD Bending Rigidity, mg*cm
50
45
40
35
30
25
20
15
10
5
0
0
10
20
30
40
50
60
70
80
Average MD, CD Tear Strength, N
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.11.

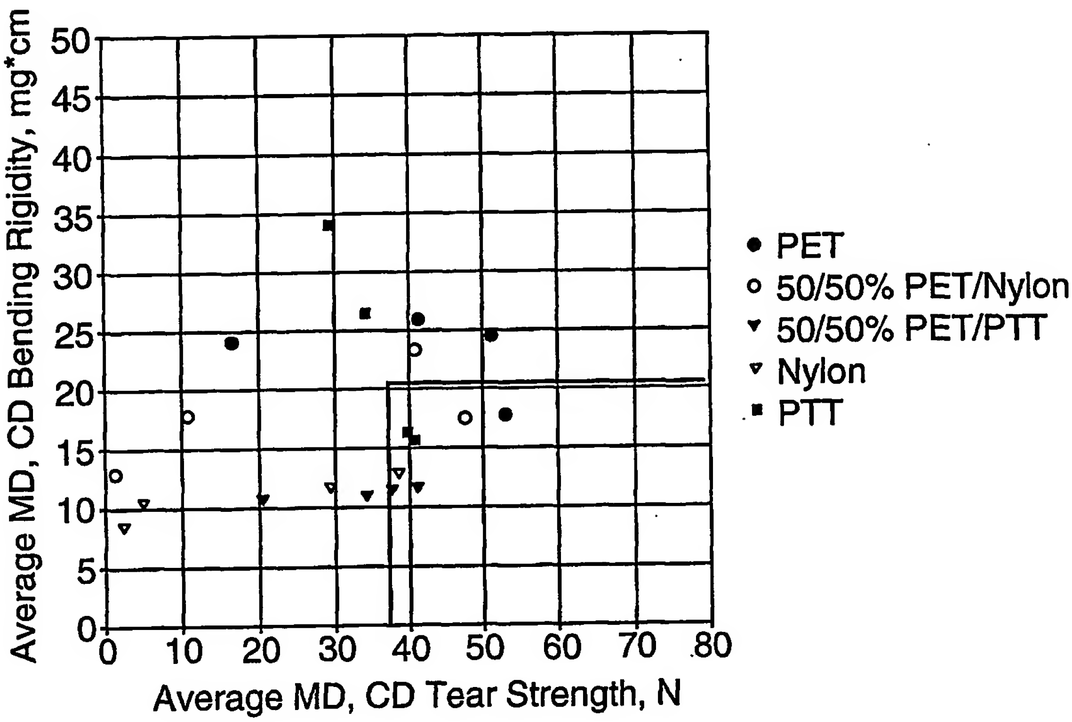

Average MD, CD Bending Rigidity, mg*cm
50
45
40
35
30
25
20
15
10
5
0
0
10
20
30
40
50
60
70
80
Average MD, CD Tear Strength, N
PET
50/50% PET/Nylon
50/50% PET/PTT
Nylon
PTT

Fig.12.

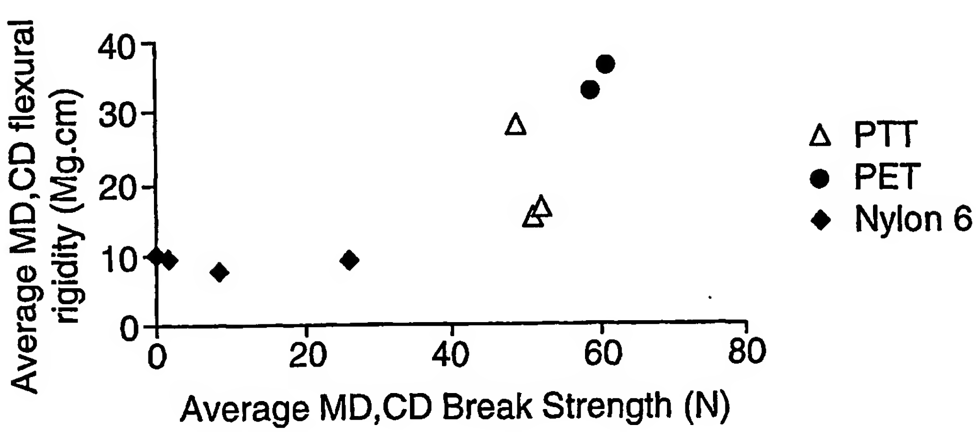
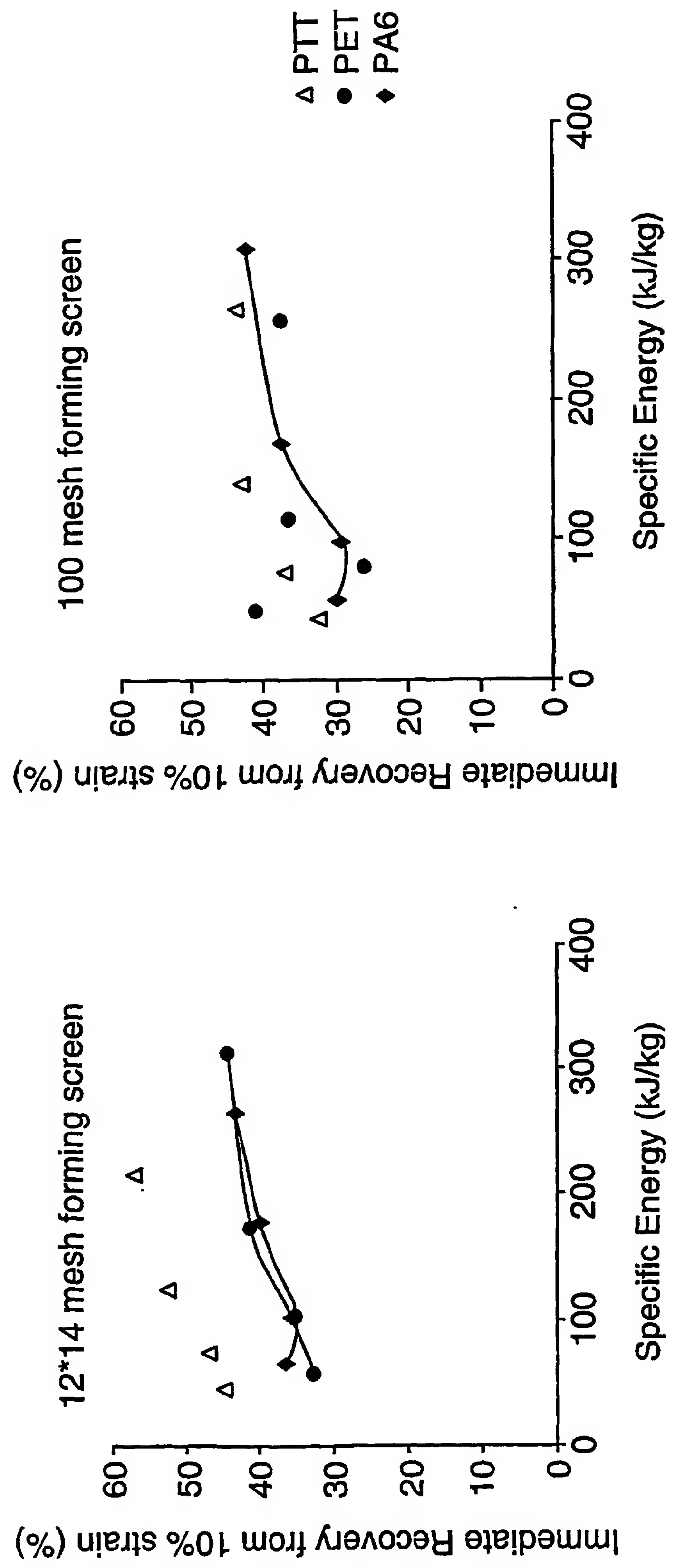

Average MD,CD flexural rigidity (Mg.cm)
40
30
20
10
0
0
20
40
60
80
Average MD,CD Break Strength (N)
PTT
PET
Nylon 6

Fig.13.


100 mesh forming screen
12*14 mesh forming screen
Immediate Recovery from 10% strain (%)
Specific Energy (kJ/kg)
PTT
PET
PA6
0
10
20
30
40
50
60
100
200
300
400

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(72) Inventors: SHIFFLER, Donald, Albert; 1700 Hardee Road, Kinston, NC 28504 (US). HWO, Charles, Chiu-Hsiung; 2710 Sugar Land Drive, Sugar Land, TX 77478 (US).

(81) Designated States *(national)*: AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW.

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For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 02/024999 A3

(54) Title: NONWOVENS FROM POLYTRIMETHYLENE TEREPHTHALATE BASED STAPLE FIBRES

(57) Abstract: A method for making a nonwoven web from staple fibres of polytrimethylene terephthalate which comprises: (a) making polytrimethylene terephthalate fibres having a cut length of from 10 to 200 millimetres and a fibre weight of 0.1 to 20 deniers per filament; (b) carding the staple fibres at a belt speed of up to 1000 meters per minute, a cross lap of web of from 1 to 50 layers and a web weight of 5 to 500 g/m² in a carding machine selected from the group consisting of roller-top, flat-top and layering types, to produce a nonwoven web; and (c) mechanically bonding the web by hydroentanglement at a belt speed of up to 500 metres per minute with from 1 to 10 multiple passes and water jet hydraulic pressure of 100 to 50000 kPa (1 to 500 bar).

INTERNATIONAL SEARCH REPORT

International Application No
PCT/EP 01/11136

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 D04H1/46 D04H1/42 D04H1/72

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 D04H

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	PATENT ABSTRACTS OF JAPAN vol. 1999, no. 09, 30 July 1999 (1999-07-30) & JP 11 107149 A (ASAHI CHEM IND CO LTD), 20 April 1999 (1999-04-20) abstract	1-6
X	& JP 11 107149 A (ASAHI CHEM IND CO LTD) 20 April 1999 (1999-04-20) paragraph '0004! paragraph '0006! paragraph '0012! paragraph '0013! paragraph '0026! paragraph '0028!	1-6

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Date of the actual completion of the international search

11 June 2002

Date of mailing of the international search report

24/06/2002

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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category °	Citation of document, with indication,where appropriate, of the relevant passages	Relevant to claim No.
A	PATENT ABSTRACTS OF JAPAN vol. 1999, no. 09, 30 July 1999 (1999-07-30) & JP 11 089869 A (ASAHI CHEM IND CO LTD), 6 April 1999 (1999-04-06) cited in the application abstract ---	1
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1

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JP 11089869	A	06-04-1999	NONE			
GB 1254826	A	24-11-1971	BE	747243	A1	14-09-1970
			CA	978715	A1	02-12-1975
			DE	2011813	A1	01-10-1970
			FR	2038039	A5	31-12-1970
			JP	49021256	B	30-05-1974
			NL	7003565	A	15-09-1970
			US	4159617	A	03-07-1979

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